

ork Order ID 122813

ly-28-14 12:49:25 PM

122813

Page 1

Item ID: D4893-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Hard Point Adapter, LH
 Start Date: 7/28/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 8/08/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4893	A								
100	BAND SAW	0.00				2	0		NH
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank:3.375" long								14/07/29
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Machine as per Folio FB193 and Dwg D4893								
	FOLIO REV: <u>AA</u>								
	DWG REV: <u>A</u>								
	DEBURR								

122813

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/28/14 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 8/08/14 **Req'd Qty:** 2.00 ***?***

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

151

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00
--	------

151

Powdercoat

Memo

0.00

Powder Coating

MASK AS PER NOTE 9

155

QC3- Inspect Part Finish	0.00
--------------------------	------

155

QC

Memo

0.00

Quality Control

Work Order ID 122813

122813

Page 4

July-28-14 12:49:25 PM

Item ID: D4893-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Hard Point Adapter, LH
 Start Date: 7/28/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 8/08/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: 51535	0.00				2X		DAS 28 9-89	AUG 14 2014
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MCS 14-08-15

@4-8-15

Picklist Print

July-28-14 12:49:24 PM

Page 1

Work Order ID: 122813

122813

Parent Item: D4893-1

D4893-1

Parent Item Name: Hard Point Adapter, LH

Start Date: 7/28/14

Required Date: 8/08/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-05-27 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X05.00 0		Purchased		No			f	3.0750		1			

M6061T6B2 000X05 000

**

6061T6 Bar 2.00 x 5.000

Location

Loc Qty

Loc Code

MAT007

3.075

m128980

3.075

m126160

*

could not pull mat

~~10~~

.6

NH

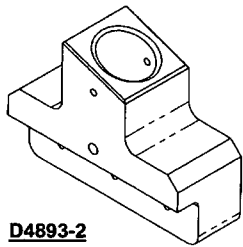
14/07/29

DART AEROSPACE LTD		Work Order: 172813
Description: Hardpoint Adapter, LH		Part Number: D4893-1
Inspection Dwg: D4893	Rev: A	Page 1 of 1

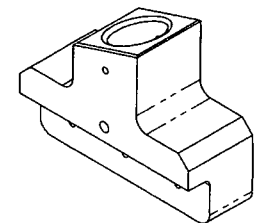
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
72°	+/-0.5°	72°	✓		MIP-06	SQUARE
1.50	+/-0.030	1.503	✓		MIP-04	vern
0.03 x 45°	+/-0.030 x +/-0.5°	0.030 x 45°	✓	
2.45	+/-0.030	2.450	✓	
1.30	+/-0.030	1.301	✓		31006	Height gauge
0.75	+/-0.030	0.753	✓		MIP-04	vern
2.500	+/-0.005	2.500	✓	
1.250	+/-0.005	1.250	✓	
R0.25	+/-0.030	0.250	✓		---	Radius gauge
0.50	+/-0.030	0.503	✓		MIP-04	vern
Ø0.129	+0.005/-0.001	0.129	✓	
Ø0.204	+0.005/-0.001	0.205	✓		↓	↓
1.50	+/-0.030	1.500	✓		↓	↓
1.00	+/-0.030	1.000	✓		↓	↓
1.00	+/-0.030	1.000	✓		↓	↓
R0.13	+/-0.030	0.130	✓		---	Radius gauge
0.83	+/-0.030	0.840	✓		MIP-04	vern
0.10 x 45°	+/-0.030 x +/-0.5°	0.100 x 45°	✓	
1.75	+/-0.030	1.750	✓	
1.46	+/-0.030	1.465	✓		31006	Height gauge
1.65	+/-0.030	1.648	✓		MIP-04	vern
4.00	+/-0.030	4.000	✓	
0.25 x 45°	+/-0.030 x +/-0.5°	0.250 x 45°	✓	
0.750	+/-0.010	0.751	✓		31006	Height gauge
Ø1.015	+0.002/-0.001	1.017	✓		MIP-04	vern

Measured by: <i>WOP</i>	Audited by: <i>Da</i>	DAS 08	Preliminary Approval:
Date: 14/08/01	Date: 14/08/01	9-89	Date:
Rev A	Date 14.07.09	Change New Issue	Revised by KJ
		Approved <i>[Signature]</i>	Approved <i>[Signature]</i>

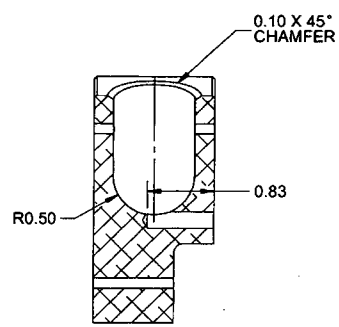
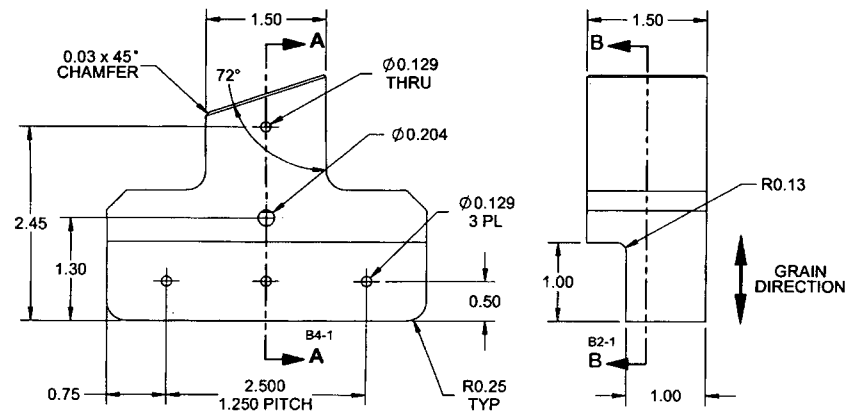


D4893-2

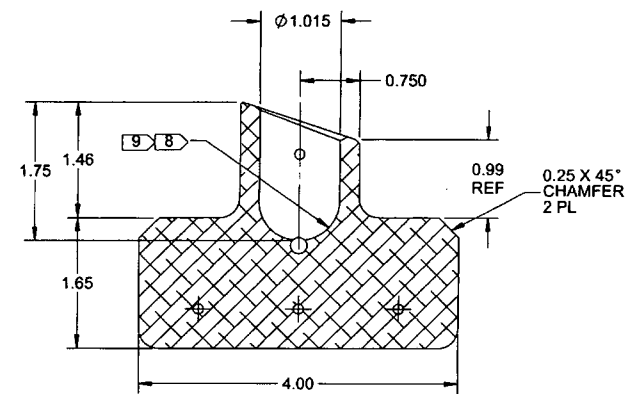


D4893-1

W/b 122813



SECTION A-A B7-1



SECTION B-B B6-1

D4893-1 HARDPOINT ADAPTER, LH
D4893-2 HARDPOINT ADAPTER, RH OPPOSITE

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
 PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
 OR ASTM B211 OR ASTM B221
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.92 lbs
- 8) SURFACE FINISH 80-125 uin. IN THE BOTTOM OF THE Ø1.015 BORE IS ACCEPTABLE
- 9) MASK Ø1.015 BORING HOLE PRIOR TO POWDER COAT

RELEASED
 2013-06-12
W/b

A NEW ISSUE		RF	13.05.24
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>OS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>27</i>	D4893	SHEET 1 OF 1
APPROVED	<i>47</i>	TITLE	SCALE
DE APPR.	<i>47</i>	HARDPOINT ADAPTER	NTS
DATE	13.05.24	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	